

split

Dart Aerospace Ltd.

Date: Friday, 5/25/2007 8:36:53 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32648
Estimate Number : 12884
P.O. Number :
This Issue : 5/25/2007 S.O. No. :
Prsht Rev. : NC
First Issue : 1/1 Type : SMALL /MED FAB
Previous Run :
Written By :
Checked & Approved By : *JA 07.05.25*
Comment : Est Rev A New Issue 07.05.24 EC

Drawing Name : ARM
Part Number : D3560044
Drawing Number : D3560 REV.B
Project Number : N/A
Drawing Revision : B
Material :
Due Date : 6/5/2007

Qty: 30 Unit Each

10

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"



Comment: Qty: 1.3598 f(s)/Unit Total: 40.7925 f(s)

6061-T6 Bar 0.50" x 5.00"

M104598 x9

Batch: *7625X1*

BC 27.06.01

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 15.500" long

BC 27.06.01

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA696 Rev: *AA* & Dwg D3560 Rev: *B*

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

JL/BC 27.06.01

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL/BC 27.06.01

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

BC 27.06.01

10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.06.05	12.8	PRESS FIT D2808 SPACER AFTER POWDER COAT. SEE ATTACHED DS EMAIL				CP 07.06.05 per QSI 042		
07.06.05	11	NO POWDER COAT. WILL BE POWDER COATED AFTER ASSEMBLY that IN D356Z STEP WELDMENT. REF ATTACHED DS EMAIL				CP 07.06.06 per QSI 042	2 07.06.07	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:36:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32648

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

PLATE

332661

07.06.06 5

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

07.06.07 5

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.06.07

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07.06.07 (5)

10.0

HAND FINISHING 1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07.06.07

(5)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

* SEE W/D CHANGE
07.06.05
NO POWDER COAT.

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07.06.07

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

GA

07.06.07

Date: Friday, 5/25/2007 8:36:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32648

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



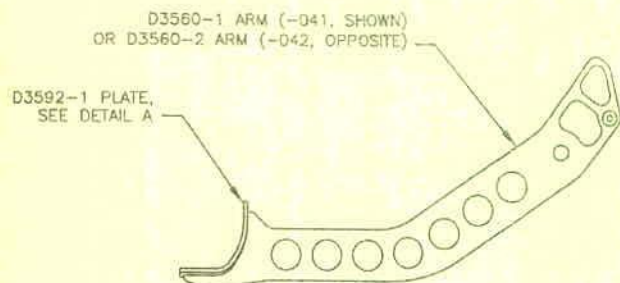
Comment: FINAL INSPECTION/W/O RELEASE

15 07-06-12 (1)

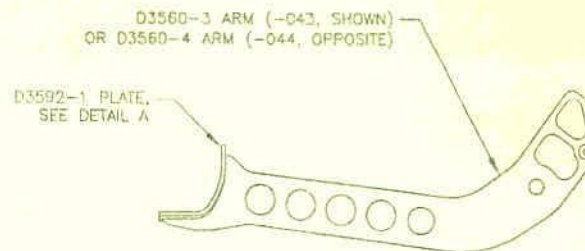
Job Completion



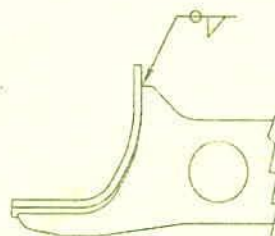
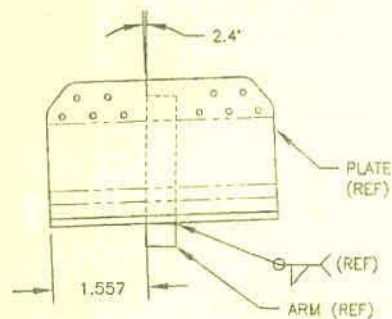
u 07-06-12 (1)



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 004 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

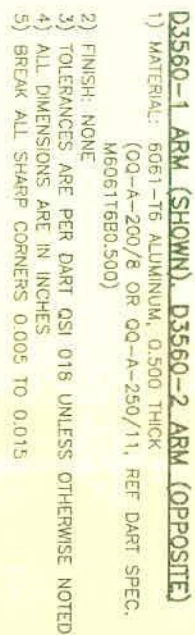
07 05.07 #

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

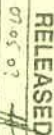
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
FOR WHICH IT WAS NOT DESIGNED OR FOR WHICH
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	q2	q2
CHECKED	#	APPROVED
DATE	07 01 15	TITLE
		ARM WELDMENT
		DART AEROSPACE LTD.
		REVISION
		SHEET 1 OF 3
		SCALE

NO. 22648



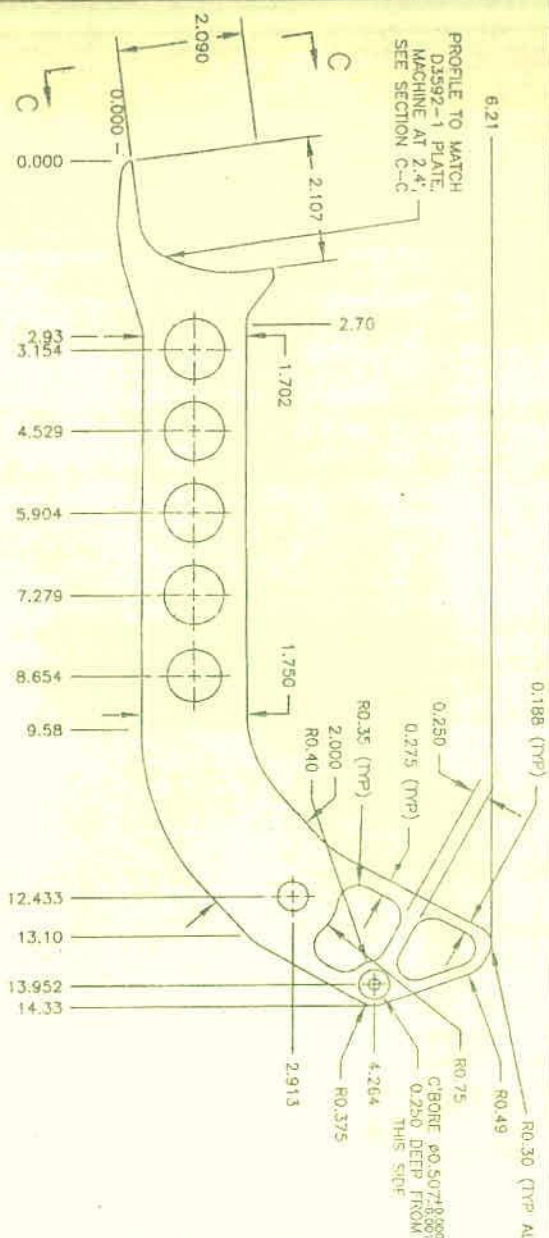
SCALE 1:1



DESIGN	Q2	DRAWN BY	Q2	 DAI DART AEROSPACE LTD. INDEPENDENT CHERRY DRIVE WILMINGTON, DELAWARE
CHECKED	18	APPROVED	18	
DATE	07.01.15	DRAWING NO.	03560	
		TITLE	ARM WEDGMENT	
				REV. B SHEET 2 OF 3 TOTAL

13

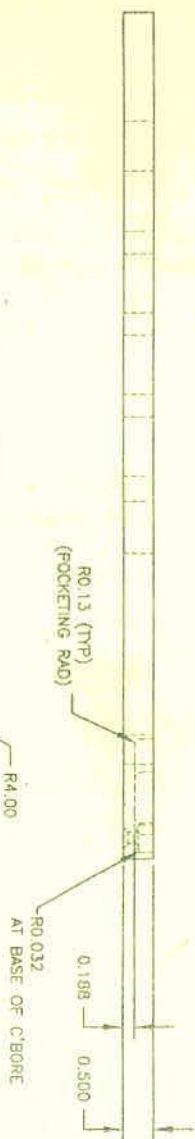
PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4',
SEE SECTION C-C



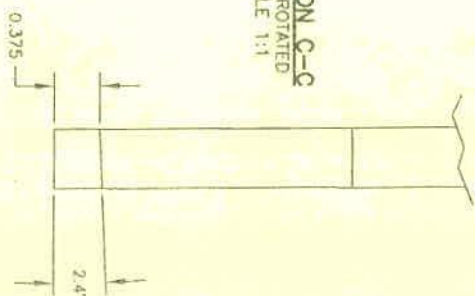
0.188 (TYP) — RO.30 (TYP) ALL OUTSIDE CORNERS EXCEPT WHERE INDICATED

D3560-3 ARM (SHOWN). D3560-4 ARM (OPPOSITE)

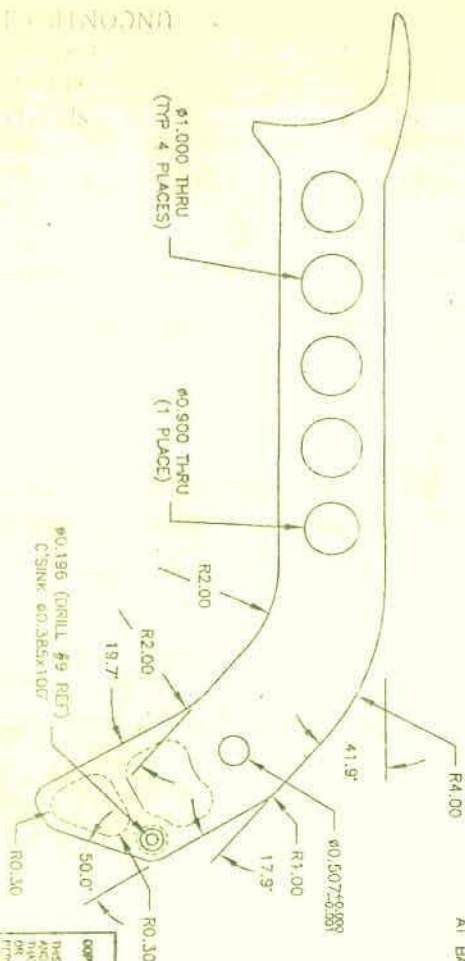
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(20-A-200/8 CR 20-A-250/11, REF DART SPEC.
M606116B0,500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QS 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C
NEW ROTATED
SCALE 1:1



RELEASE



THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR CONTAINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DOW. DOW AGROSCIENCES LTD.

DESIGN	qp	DATA	qp	DATA	DATA AEROSPACE LTD.
		APPROVAL	qp		Mississauga, Ontario, Canada
ORDERED				DRAWING NO.	REV. B
				D3560	SHEET 3 OF 3
DATE	07.01.15			TITLE	SOLE
				AIRM WEDGMENT	1-2

87922

DART AEROSPACE LTD		Work Order: 32648
Description: A21		Part Number: D3560-1
Inspection Dwg: D3560 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
13.952	±0.10	13.952	✓			
12.433	"	12.433	✓			
2.913	"	2.913	✓			
4.264	"	4.264	✓			
1.722	"	1.722	✓			
.250	"	.250	✓			
.188	"	.188	✓			
.275	"	.275	✓			
2.000	"	2.000	✓			
1.750	"	1.750	✓			
.48	"	.48	✓			
.500	"	.500	✓			
12.13	±.103	12.13	✓			
Ø1.000	±.010	1.000	✓			
Ø.900	"	.900	✓			
Ø.196	+0.003 -0.001	.199	✓			
Ø.507	+0.000 -0.001	.5065	✓			
Ø.507	"	.5065	✓			
3.75 X 100°	"	3.75	✓			
.375	±.010	.375	✓			

Measured by: JG	Audited by: J.L.	Prototype Approval:
Date: 07/06/01	Date: 07/06/01	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 5, 2007 5:18 PM
To: 'Chris Provencal'
Subject: RE: D3562-041/-042

As we have discussed previously, this is acceptable as long as the Magnabond doesn't break down.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Tuesday, June 05, 2007 11:00 AM
To: David Shepherd (David Shepherd)
Subject: D3562-041/-042

David,

For the D3562-041/-042 step weldment, as discussed. They want to switch from Sikaflex to Magnabond, and powder coat after final assembly.

As part of this change, the D3560-XX arms won't be powder coated, and the D2808 Bushing won't be assembled until after final assembly of the step weldment.

Since this is the first time trying this, we will ensure that the steps are checked after powdercoating in case the Magnabond doesn't do anything unexpected (eg. bubbling). If we see anything suspect, we will assemble them the old way.

Is this acceptable.

-Chris

No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

